

Work Order ID 56908

March 12, 2010 1:27:35 PM



Page 1

Item ID: D3694-5

Accept



Setup Start



Revision ID:

Item Name: MOUNTING PLATE ASSY

Stop



Start Date: 12/03/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 26/03/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan:



Date: 10-3-15 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3694

C

100



FLOW WATER JET

Waterjet

Memo

FLOW CNC Waterjet

6061 .125

1-Cut as per Dwg D3694
Dwg Rev: 2
Prog Rev: 2
2-Deburr if necessary

0.00

10-3-16

(9)

110



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

10-3-16

Quality Control

120



QC8- Inspect parts - second check

QC

Memo

0.00

Solos 12

0.00

(8)

Pro →

Quality Control

WO: 56908		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/3/17	# 120	Took Qty 4 for inspection template	S	10/05/17	X1		S 10/05/17

Part No: D3694-S PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Reference:

Approvals: Process Plan: _____

Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center ID

130



Small Fab

Operation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

0.00

1- Counter sink holes 0.204" (4 places) as per dwg D3694
2- deburr

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

W/O:		WORK ORDER CHANGES					
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Work Order ID 56908

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Item ID: D3694-5

Revision ID:

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Start Date: 12/03/2010 Start Qty: 8.00

Required Date: 26/03/2010 Req'd Qty: 8.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

155



Powdercoat

Powder Coating

Operation
Description

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

11112588

Memo

POWDER COAT:
Start Time: 7:30 AM
Oven Temperature: 320° F
Finish Time: 8:00 AM

Set Up/
Run Hours

0.00

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

0.00

-> 11/10/03/22

(X)

/

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

11/10/3/22 (8)

170



Packaging

Packaging

Identify as per dwg & Stock Location: 265

0.00

Memo

0.00

11/10/3/22 (8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID 56908

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Page 4

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Stop



Start Date: 12/03/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 26/03/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

180

Operation
Description

QC21- Final Inspection - Work Order Release

Set Up/
Run Hours

0.00

Draw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

QC

Quality Control

Memo

0.00

10/03/04 JJ

10-3-07
EC

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

March 12, 2010 1:27:40 PM

Page 1

Work Order ID: 56908



Parent Item: D3694-5



Parent Item Name: MOUNTING PLATE ASSY

Start Date: 12/03/2010

Required Date: 26/03/2010

Comments: IPP Rev:A new issue 09-01-12 DD verified by:JLM

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.125		Purchased	No			100	sf	217.0801	5.6926	6.5		

6061-T6 .125 Sheet



Warehouse

Location

Main Warehouse

MAT	Loc Qty	Loc Code
110062	1.85	
111642	19.592	
112476	32	
112567	18.7403	
113424	48.8978	1B4D4
113608	96	

(9)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	56998
Description: Mounting Plate	Part Number:	D3694-5
Inspection Dwg: D3694 Rev: C		Page 1 of 1

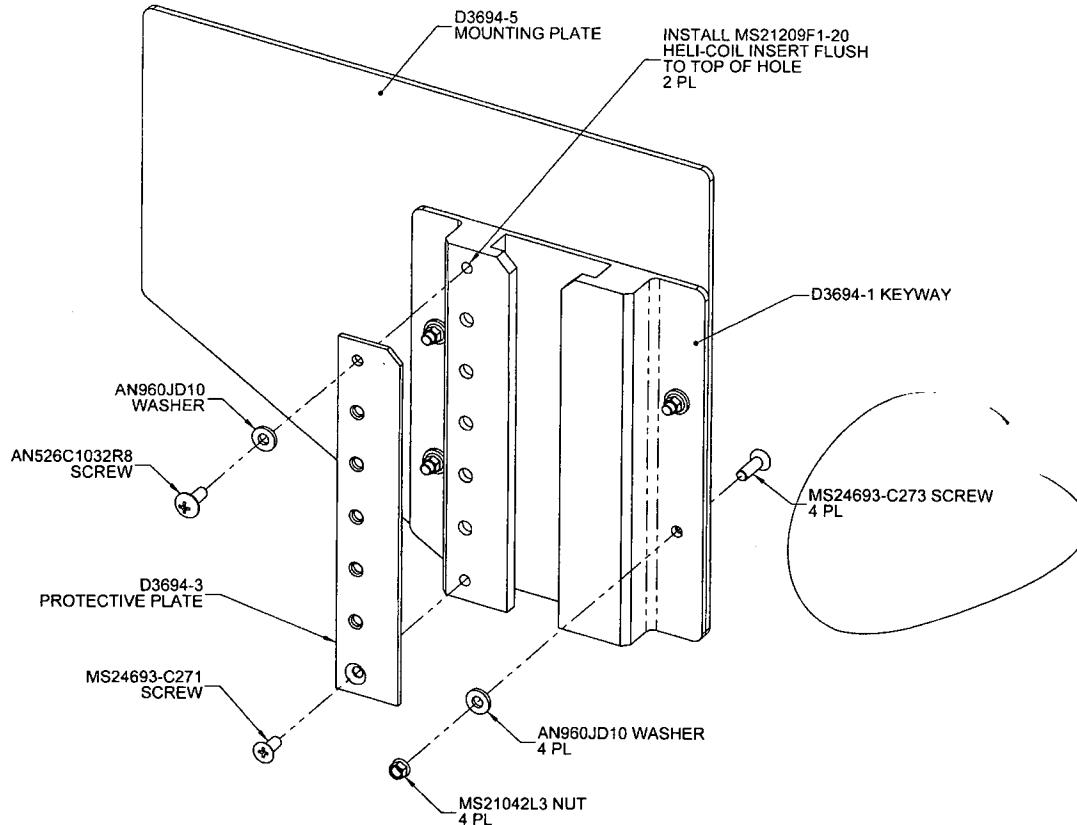
FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	HB	Audited by:	S	Prototype Approval:	N/A
Date:	10-3-14	Date:	10/03/14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.11.11	New Issue	KJ	AA

8 7 6 5 4 3 2 1



D3694-041 MOUNTING PLATE ASSY

A
D3694-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3694-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.70 lbs

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3694-041	MOUNTING PLATE ASSY
11	1	D3694-1	KEYWAY
12	1	D3694-3	PROTECTIVE PLATE
13	1	D3694-5	MOUNTING PLATE
21	1	AN526C1032R8	SCREW
22	5	AN960JD10	WASHER
23	4	MS21042L3	NUT
24	2	MS21209F1-20	HELI-COIL, SCREW LOCKING (RED)
25	1	MS24693-C271	SCREW
26	4	MS24693-C273	SCREW

D
C
B
A
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 50008
28-03-15

B
RELEASED
09/03/08

C	REDESIGNED ITEM 11; REVISED ITEM 12: DIM $\phi 0.204$ WAS 0.234 (ZN D3-3); ADDED ITEM 13; UPDATED BOM TO CURRENT STANDARDS (ZN D3-1). REASON: ENSURE COMPATIBILITY WITH ELIGIBLE OEM AIRCRAFT POSTS AND ELIMINATE SLOPPY FIT.	MB	08.11.03
B	QTY 1 MS24693-C271 SCREW WAS QTY. 2 (ZN D3-1); ADD AN526C1032R8 SCREW AND AN960JD10 WASHER (ZN D3-1, ZN D3-1); 1.18 WAS 1.15 (ZN C3-3). CSK WAS 2 PL (ZN D3-3), 0.78 WAS 0.785 (ZN C3-3). REASON: REDESIGN TO USE AN526 TYPE SCREW HEAD AS SAFETY STOP	MB	08.06.26
A	NEW ISSUE	MB	08.03.14
REV.	DESCRIPTION	BY	DATE
DESIGN	<u>1A</u>	DART AEROSPACE LTD	
DRAWN	<u>1A</u>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<u>1A</u>	DRAWING NO.	REV. C
MFG. APPR.	<u>1A</u>	D3694	SHEET 1 OF 4
APPROVED	<u>1A</u>	TITLE	SCALE
DE APPR.	<u>1A</u>	MOUNTING PLATE ASSY	NTS
DATE	08.11.03	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUBJECT TO THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY OTHER PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

8 7 6 5 4 3 2 1

D

C

B

A

1

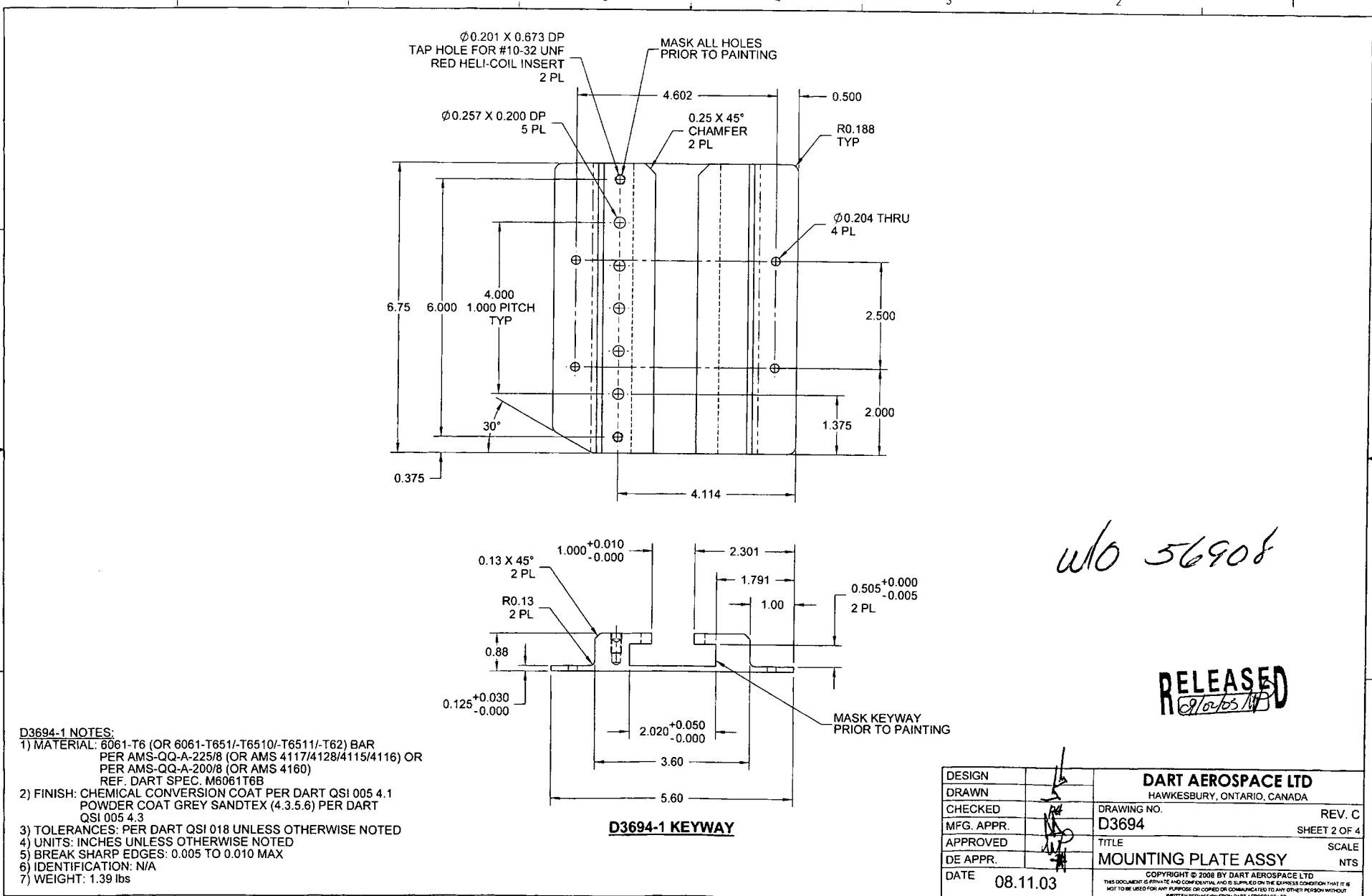
W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries



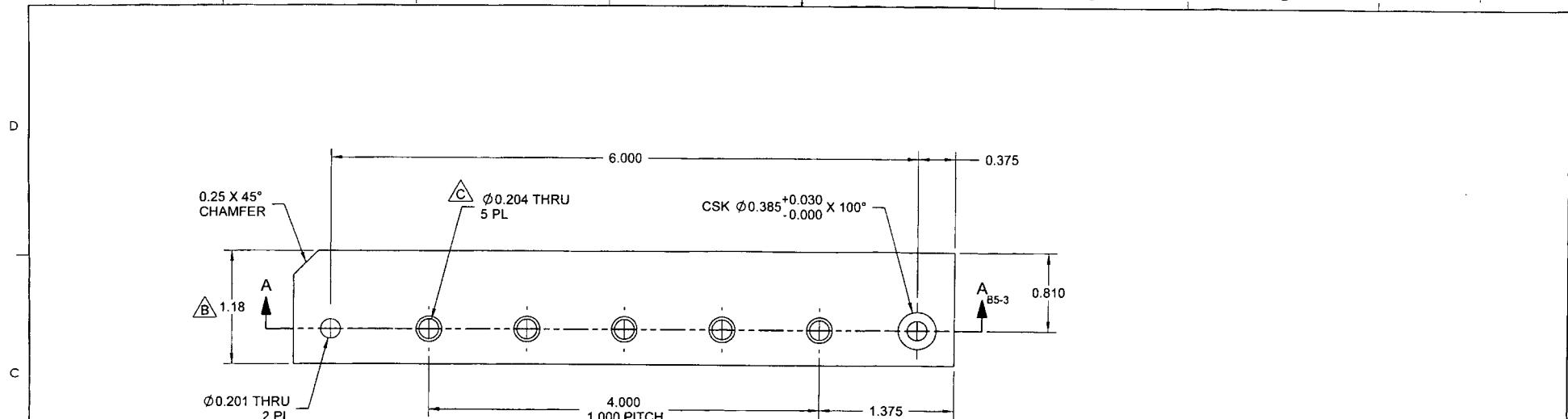
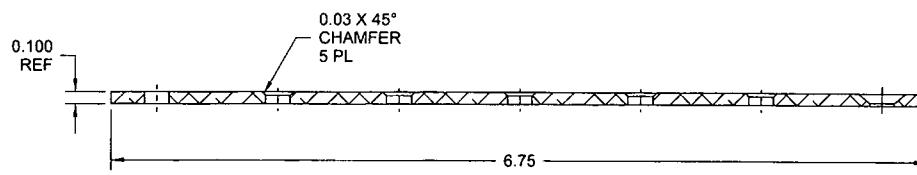
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D3694-3 PROTECTIVE PLATESECTION A-Ac3-3

w/o 56908

RELEASED
07/25/08

A D3694-3 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 12 GAUGE (0.100 THICK), PER PER AMS 5513 OR AMS 5524 REF. DART SPEC. M304S12GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.22 lbs

8 7 6 5 4 3 2 1

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	DRAWING NO. REV. C
MFG. APPR.	<i>[Signature]</i>	D3694 SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE SCALE
DE APPR.	<i>[Signature]</i>	NTS
DATE	08.11.03	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OTHER THAN THAT FOR WHICH IT WAS ISSUED, OR PROVIDED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

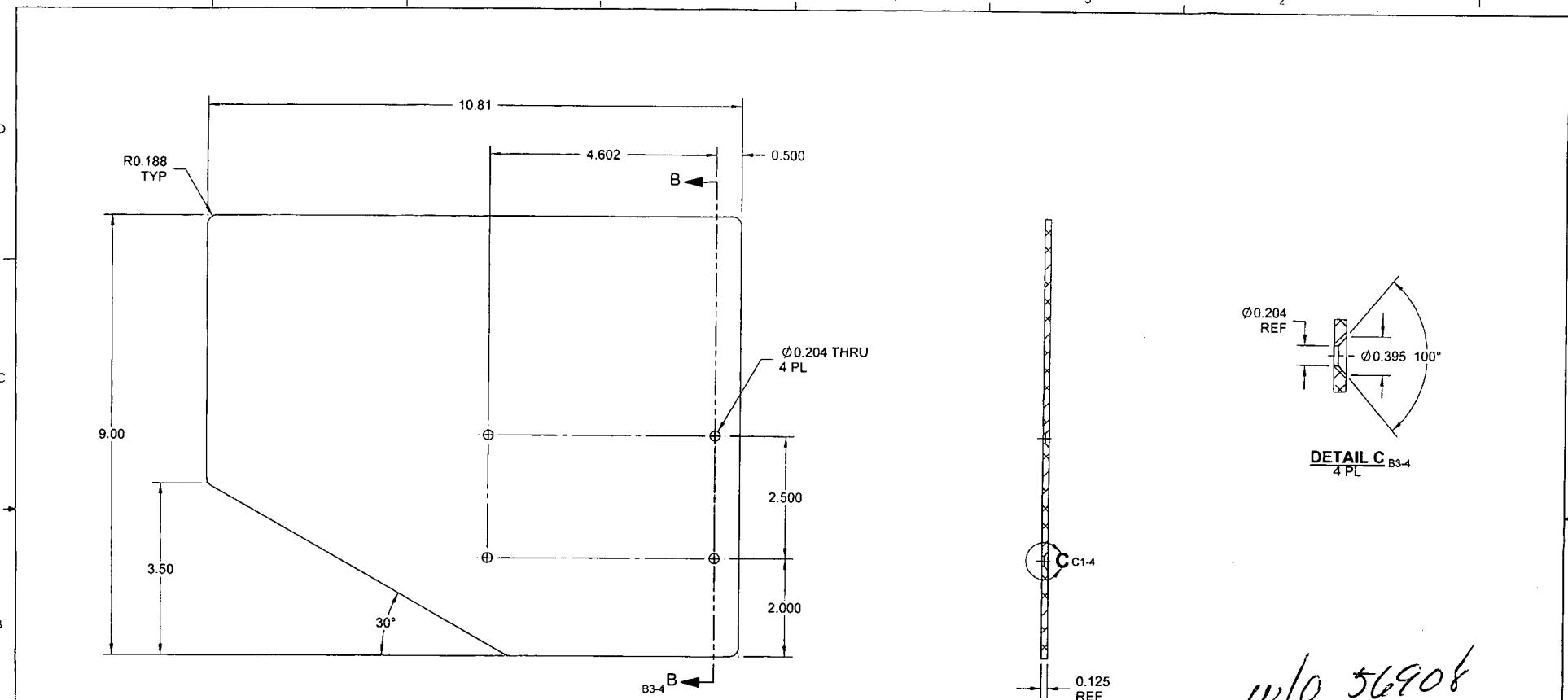
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D3694-5 MOUNTING PLATESECTION B-B B3-4

w/o 56908

RELEASED
09/06/05 MA

D3694-5 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.125 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR OR AMS 4027 REF. DART SPEC. M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.08 lbs

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	REV. C	
MFG. APPR.	<i>[Signature]</i>	DRAWING NO.	D3694
APPROVED	<i>[Signature]</i>	REV. 4 OF 4	SHEET 4 OF 4
DE APPR.	<i>[Signature]</i>	TITLE	SCALE
DATE	08.11.03	MOUNTING PLATE ASSY NTS	

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8 7 6 5 4 3 2 1

1

W/O:		WORK ORDER CHANGES					
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